

Work Order ID 68695

Wednesday, April 20, 2011 8:24:48 AM



Page 1

Item ID: D3778-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date:

4/20/2011

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3778	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3778 ☒ Dwg Rev: *A* ☐ Prog Rev: *A* ☐
****grain direction along 2.34" ****☐ 2-Deburr if necessary

5052.096

B11-4-21

Handwritten circled '8'

110

QC2- Inspect parts off machine FAI/FAJB

0.00



QC

Memo

0.00

Quality Control

B11-4-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Handwritten signature

Handwritten circled 'X4'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-deburr

□2-Bend as per Dwg D3778

SB 11/04/25

(8)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sub 11/04/25

(8)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

8 BR 11-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 4/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



M115 128.

Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:20*

☐ OVEN TEMPERATURE:

320° ☐ FINISH TIME:

10:50.

8 BR 11-4-26

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 of 11 11/4/26

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/4/208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3778-1

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Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/27

CMF
11-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 8:24:55 AM

Page 1

Work Order ID: 68695



Parent Item: D3778-1



Parent Item Name: Bracket



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue 08-04-15 DD verified by:EC
IPP Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC
IPP Rev:C 08-05-22 add powder coating DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090 		Purchased	No			100	sf	21.5000	0.0934	0.589895			
5052-H32 .090 Sheet													

B11-4-21

Location

Loc Qty

Loc Code

MAT22

21.5

3019

21.5

3019

8

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68695
Description: Bracket		Part Number:	D3778-1
Inspection Dwg: D3778	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		V 1302	
0.30	+/-0.030	.300	✓		V	
0.30	+/-0.030	.297	✓		V	
Ø0.635	+/-0.005	.636	✗		V	
0.400	+/-0.010	.400	✓		V	
0.468	+/-0.010	.468	✓		V	
1.50	+/-0.030	1.500	✓		V	
2.750	+/-0.010	2.758	✓		V	
2.34	+/-0.030	2.342	✓		V	
5.75	+/-0.030	5.755	✓		V	
0.090	+/-0.010	.087	✓		V	
Ø0.500	+/-0.005	.501	✗		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-4-21	Date: 11/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.07	New Issue	KJ/DD	

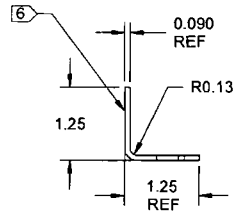
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

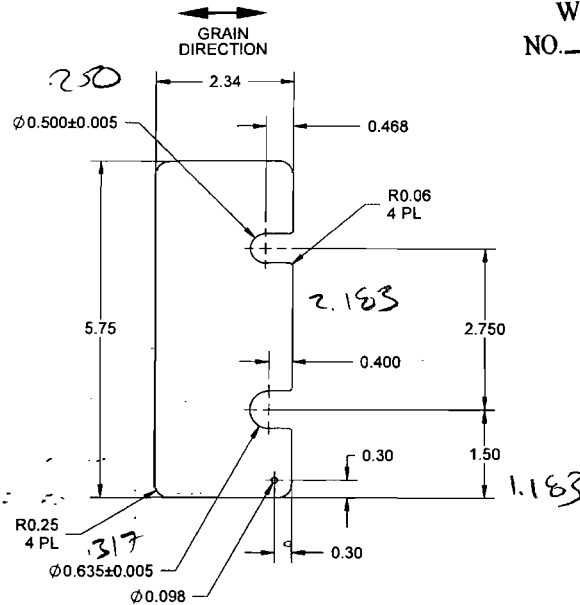
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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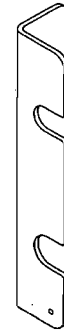
D3778-1 BRACKET



D3778-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48695

pl11-001-21



RELEASED
08.05.13

NOTES:

- 1) MATERIAL: 6052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/-T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-1" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.11 lbs

A	NEW ISSUE	PH	08.04.11
REV	DESCRIPTION	BY	DATE
DESIGN	<i>AK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AK</i>		
CHECKED	<i>SP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>TH</i>	D3778	SHEET 1 OF 1
APPROVED	<i>TH</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	BRACKET	NTS
DATE	08.04.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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